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**D3492-1****Job Sheet 191066****Part No:** D3492-1**Job Qty:** 60 pcs**Part Name:** Plug**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 3/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation                     | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off   |
|-------|-------------------------------|--------|------------|----------|-----------|---------|--------------------------|-----------|------------|
|       |                               |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |            |
| 100   | Hardinge - 1                  | 60 pcs |            | 3/18/19  | 0.00      | 1.84    | Hardinge - 1             |           | 19/3/19    |
| 120   | QC 8                          | 60 pcs |            | 3/18/19  | 0.00      | 0.00    | QC 8 - 12                |           | m 19/03/19 |
|       |                               |        |            |          |           |         | QC 8 - 14                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 17                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 20                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 25                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 3                 |           |            |
|       |                               |        |            |          |           |         | QC 8 - 32                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 33                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 35                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 39                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 4                 |           |            |
|       |                               |        |            |          |           |         | QC 8 - 44                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 45                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 49                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 58                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 8                 |           |            |
|       |                               |        |            |          |           |         | QC 8 - 9                 |           |            |
|       |                               |        |            |          |           |         | QC 8 - 68                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 67                |           |            |
|       |                               |        |            |          |           |         | QC 8 - 1 (A)             |           |            |
|       |                               |        |            |          |           |         | QC 8 - 47                |           |            |
| 150   | Handfinish - 1-1 Chemical-B4B | 60 pcs |            | 3/18/19  | 0.00      | 0.20    | Handfinish - 1 - 1 - B4B |           |            |
|       |                               |        |            |          |           |         | Handfinish - 1 - 2 - B4B |           |            |
|       |                               |        |            |          |           |         | Handfinish - 1 - 3 - B4B |           |            |
|       |                               |        |            |          |           |         | Handfinish - 1 - 4 - B4B |           |            |
|       |                               |        |            |          |           |         | Handfinish - 1 - 5 -     |           |            |

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|     |                                 |        |         |           |                           |             |
|-----|---------------------------------|--------|---------|-----------|---------------------------|-------------|
|     |                                 |        |         |           | B4B                       |             |
|     |                                 |        |         |           | Handfinish - 1 - 6 - B4B  |             |
|     |                                 |        |         |           | Handfinish - 1 - 7 - B4B  |             |
|     |                                 |        |         |           | Handfinish - 1 - 8 - B4B  |             |
|     |                                 |        |         |           | Handfinish - 1 - 9 - B4B  |             |
|     |                                 |        |         |           | Handfinish - 1 - 10 - B4B | DR 19/03/19 |
|     |                                 |        |         |           | Handfinish - 1 - 11 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 12 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 13 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 14 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 15 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 16 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 17 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 18 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 19 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 20 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 21 - B4B |             |
|     |                                 |        |         |           | Handfinish - 1 - 22 - B4B |             |
| 160 | Powdercoat - 1 White Gl(A)- B4B | 60 pcs | 3/18/19 | 0.00 0.09 | Powdercoat - 1 - B4B      |             |
|     |                                 |        |         |           | Powdercoat - 2 - B4B      |             |
|     |                                 |        |         |           | Powdercoat - 3 - B4B      | 14-03-26    |
|     |                                 |        |         |           | Powdercoat - 4 - B4B      |             |
| 170 | QC 3                            | 60 pcs | 3/18/19 | 0.00 0.00 | QC 3 - 10                 |             |
|     |                                 |        |         |           | QC 3 - 13                 |             |
|     |                                 |        |         |           | QC 3 - 15                 |             |
|     |                                 |        |         |           | QC 3 - 17                 |             |
|     |                                 |        |         |           | QC 3 - 18                 |             |
|     |                                 |        |         |           | QC 3 - 2                  |             |
|     |                                 |        |         |           | QC 3 - 26                 |             |
|     |                                 |        |         |           | QC 3 - 28                 |             |
|     |                                 |        |         |           | QC 3 - 3                  |             |
|     |                                 |        |         |           | QC 3 - 30                 |             |
|     |                                 |        |         |           | QC 3 - 34                 |             |
|     |                                 |        |         |           | QC 3 - 36                 |             |
|     |                                 |        |         |           | QC 3 - 41                 |             |
|     |                                 |        |         |           | QC 3 - 51                 |             |
|     |                                 |        |         |           | QC 3 - 58                 |             |
|     |                                 |        |         |           | QC 3 - 59                 |             |
|     |                                 |        |         |           | QC 3 - 6                  |             |
|     |                                 |        |         |           | QC 3 - 68                 |             |
|     |                                 |        |         |           | QC 3 - 9                  |             |
| 180 | Packaging 3-1 - Stock - B4B     | 60 pcs | 3/18/19 | 0.00 0.00 | Packaging 3 - 1 - B4B     |             |
|     |                                 |        |         |           | Packaging 3 - 2 - B4B     |             |
|     |                                 |        |         |           | Packaging 3 - 3 - B4B     |             |
|     |                                 |        |         |           | Packaging 3 - 4 - B4B     |             |

|     |            |     |         |                        |                 |      |
|-----|------------|-----|---------|------------------------|-----------------|------|
|     |            |     |         | Packaging 3 - 5 - B4B  | DAS             |      |
|     |            |     |         | Packaging 3 - 6 - B4B  | 28              |      |
|     |            |     |         | Packaging 3 - 7 - B4B  | 9-89            |      |
|     |            |     |         | Packaging 3 - 8 - B4B  |                 |      |
|     |            |     |         | Packaging 3 - 9 - B4B  |                 |      |
|     |            |     |         | Packaging 3 - 10 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 11 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 12 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 13 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 14 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 15 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 16 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 17 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 18 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 19 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 20 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 21 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 22 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 23 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 24 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 25 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 26 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 27 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 28 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 29 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 30 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 31 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 32 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 33 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 34 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 35 - B4B |                 |      |
|     |            |     |         | Packaging 3 - 36 - B4B |                 |      |
| 190 | QC 21 - SA | 60  | 3/18/19 | 0.00 0.00              | QC 21 - SA - 21 | DAS  |
|     |            | pcs |         |                        | QC 21 - SA - 70 | 21   |
|     |            |     |         |                        | QC 21 - SA - 53 | 9-89 |

Part Op **100** - (Hardinge) 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: E  
 Descriptions: **120** - (QC8- Inspect parts - second check)  
**150** - (Chemical Conversion Coat per QSI005 4.1)  
**160** - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only) START TIME: 3:10 FINISH TIME: 3:40  
01.1.320° M 138997  
**170** - (QC3- Inspect Part Finish)  
**180** - (Identify as per dwg & Stock Location: \_\_\_\_\_) LOCATION : FP001  
**190** - (QC21- Final Inspection - Work Order Release)

MAR 27 2019

## Job BOM

| Part / Item   | Component Name          | Quantity            | Operation        | Container          |
|---------------|-------------------------|---------------------|------------------|--------------------|
| M6061T6R0.625 | 6061-T6 Round Bar .625" | 3.1800 ft (.053 ea) | 100-Hardinge - 1 | 5090365<br>5150604 |

## Job Allocations

| Operation        | Component Part | Required | Inventory | Allocated |
|------------------|----------------|----------|-----------|-----------|
| 100-Hardinge - 1 | M6061T6R0.625  | 3        | 39        | 0         |



| Part Specifications |             |                                |                  |      |                  |
|---------------------|-------------|--------------------------------|------------------|------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits           | Type | Special Comments |
| 1                   | Plug        | 0.060inches $\pm$ 0.005        | 0.065<br>0.055   |      |                  |
| 2                   | Plug        | 0.060inches $\pm$ 0.005        | 0.065<br>0.055   |      |                  |
| 3                   | Plug        | 0.394inches $\pm$ 0.010        | 0.404<br>0.384   |      |                  |
| 4                   | Plug        | 0.625inches $\pm$ 0.010        | 0.635<br>0.615   |      |                  |
| 5                   | Plug        | 0.090inches + 0.000<br>- 0.002 | 0.090<br>0.088   |      |                  |
| 6                   | Plug        | 0.500inches $\pm$ 0.010        | 0.510<br>0.490   |      |                  |
| 7                   | Plug        | 0.050inches + 0.000<br>- 0.002 | 0.050<br>0.048   |      |                  |
| 8                   | Plug        | 0.050inches $\pm$ 0.010        | 0.060<br>0.040   |      |                  |
| 9                   | Plug        | 20.000Degrees $\pm$ 0.000      | 20.000<br>20.000 |      |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



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**Container No: S163857**



**Part: D3492-1**

**Job No: 191066**

**Serial No/Batch: S163857**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 03/19/19**